Dart Aerospace Ltd.

Date: Thursday, 9/6/2007 8:50:36 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER MOTOR ADAPTER
Job Number	: 34440		
Estimate Number	: 12133		
P.O. Number	: N/A	Part Number	: D3476043
This Issue	: 9/6/2007 S.O. No. : N/A	Drawing Number	: D3476 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 34084	Material	: N/A
Written By	:	Due Date	: 9/13/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.09.06		

Comment : Est Rev:A New Issue 06-01-31 JLM
est rev B added commment @ # 5.0 06.11.01 EC

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D34763	DOME

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty	Part Number	Description	Batch
1	D3476-3	blower motor adapter	B27025

mf 07-09-06

Seq. #:	Machine Or Operation:	Description :
2.0	D34767	TUBE

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty	Part Number	Description	Batch
2	D3476-7	Tube	~~B-28590~~ B34105

mf

Seq. #:	Machine Or Operation:	Description :
3.0	D34761	duct

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty	Part Number	Description	Batch
1	D3476-1	Duct	~~B34476~~ B34104

mf 07-09-06

Seq. #:	Machine Or Operation:	Description :
4.0	NAS1031C3W	Nutplate

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty	Part Number	Description	Batch
4	NAS-1031C3W	Nutplate	M101462

mf 07-09-06

Seq. #:	Machine Or Operation:	Description :
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spot Weld Tubes And Nut plates as per Dwg D3476 and Dart QSI 018
********* D3476-1 goes on top of D3476-3 *************

mf 07-09-06 (1)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/09/11

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
07.09.06	5.0	DUCT D3476-1 WELDED OUTSIDE D3476-3 DOME QTY. = 1.	[initials] 07.09.06	ACCEPTABLE DEVIATION	N/A	[signature] 07.09.11	[signature] 07.09.06	[signature] 07.09.11

NOTE: Date & initial all entries

Date: Thursday, 9/6/2007 8:50:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 34440 | Part Number: D3476043

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC11	VISUAL INSPECTION OF SPOT WELDING
	Comment: VISUAL INSPECTION OF SPOT WELDING	SB 07/09/06
7.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	SB 07/09/06
8.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: G-A	SB 07/09/06
9.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	07/09/11

Job Completion

U 07.09.07

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

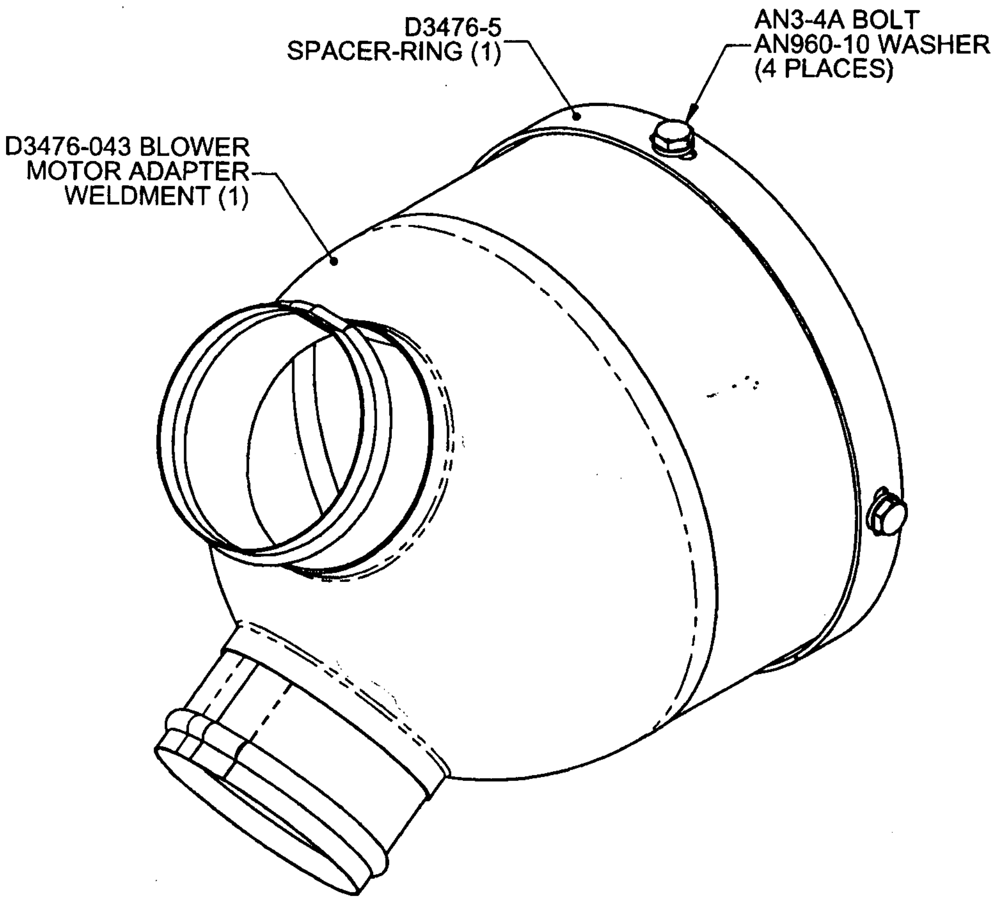
QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3476 — REV. A — SHEET 1 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER — SCALE 1:2
A	06.01.27	NEW ISSUE



D3476-041 BLOWER MOTOR ADAPTER

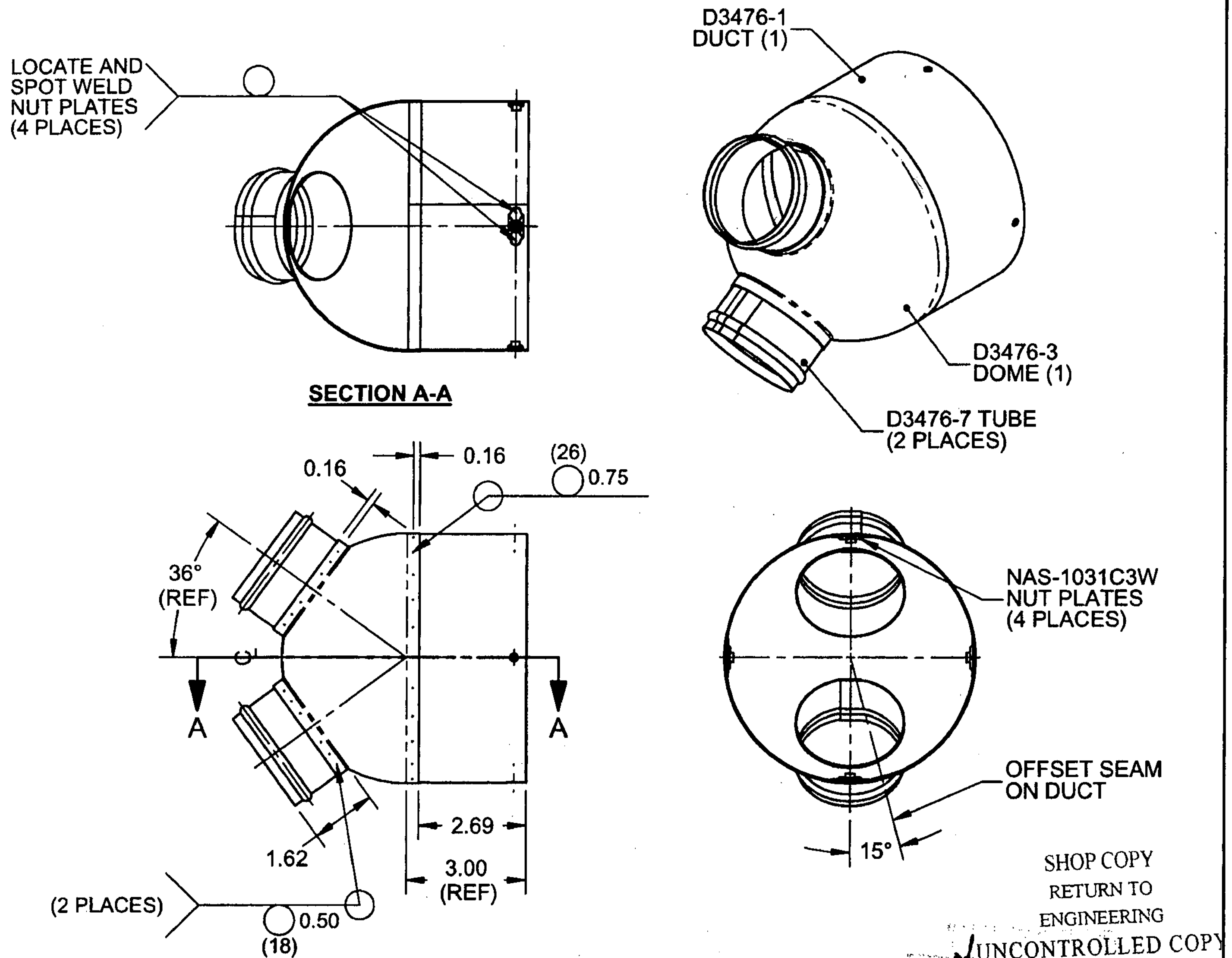
1) IDENTIFY WITH DART P/N D3476-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	**D3476-041**	**BLOWER MOTOR ADAPTER**
1	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-5	SPACER-RING
4	AN3-4A	BOLT
4	AN960-10	WASHER

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WORK ORDER NO. 34440

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3476 REV. A SHEET 2 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER SCALE 1:4



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WORK ORDER
NO. 34440

D3476-043 BLOWER MOTOR ADAPTER WELDMENT

NOTES:

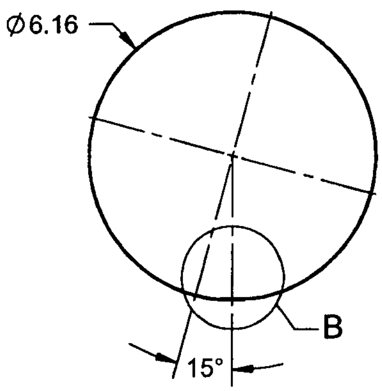
1) SPOT WELD PER DART QSI 004
2) FINISH: NONE
3) PART IS SYMETRICAL ABOUT CENTERLINE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

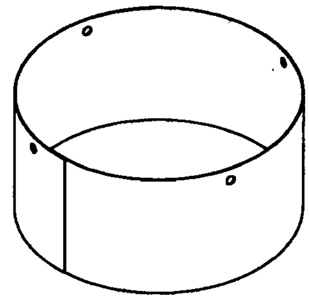
QTY -043	P/N	DESCRIPTION
X	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-1	DUCT
1	D3476-3	DOME
2	D3476-7	TUBE
4	NAS1031C3W	NUTPLATE

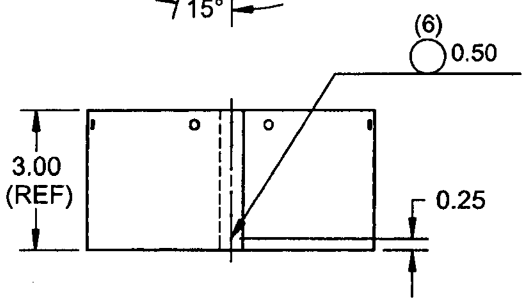
DART

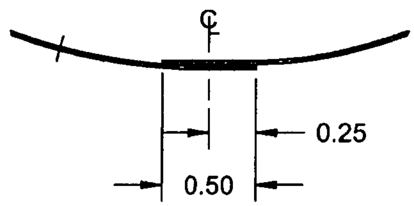
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3476 — REV. A — SHEET 3 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER — SCALE 1:4

06.01.03



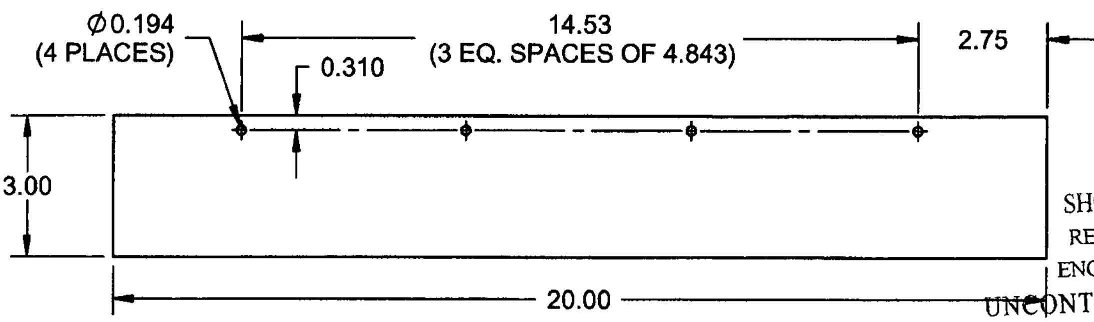






DETAIL B
SCALE 1 : 1

D3476-1 DUCT



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NO. 34440

D3476-1F DUCT FLAT PATTERN

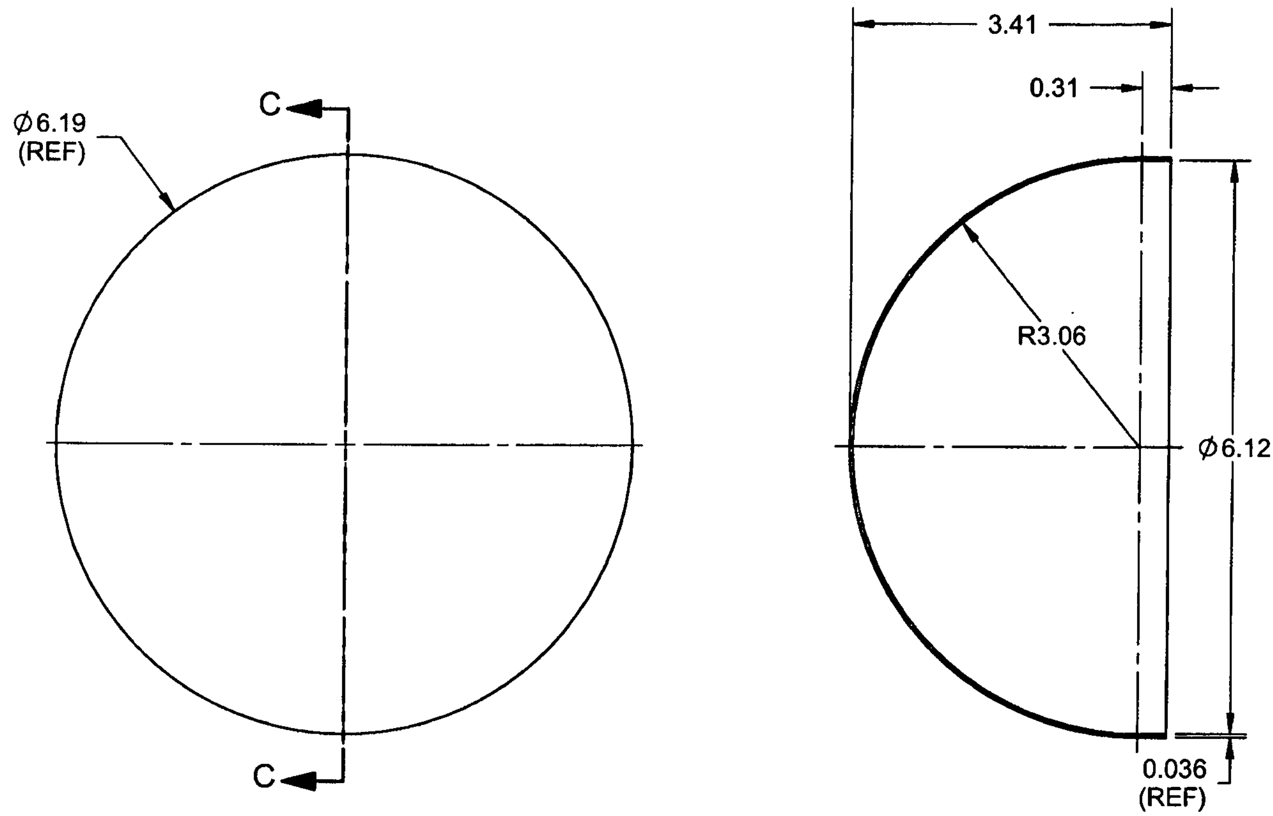
NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
2) SPOT WELD PER DART QSI 004
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3476 — REV. A — SHEET 4 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER — SCALE 1:2

RELEASED
06.04.03



SECTION C-C

D3476-3S DOME, SPINNING DETAIL

NOTES:

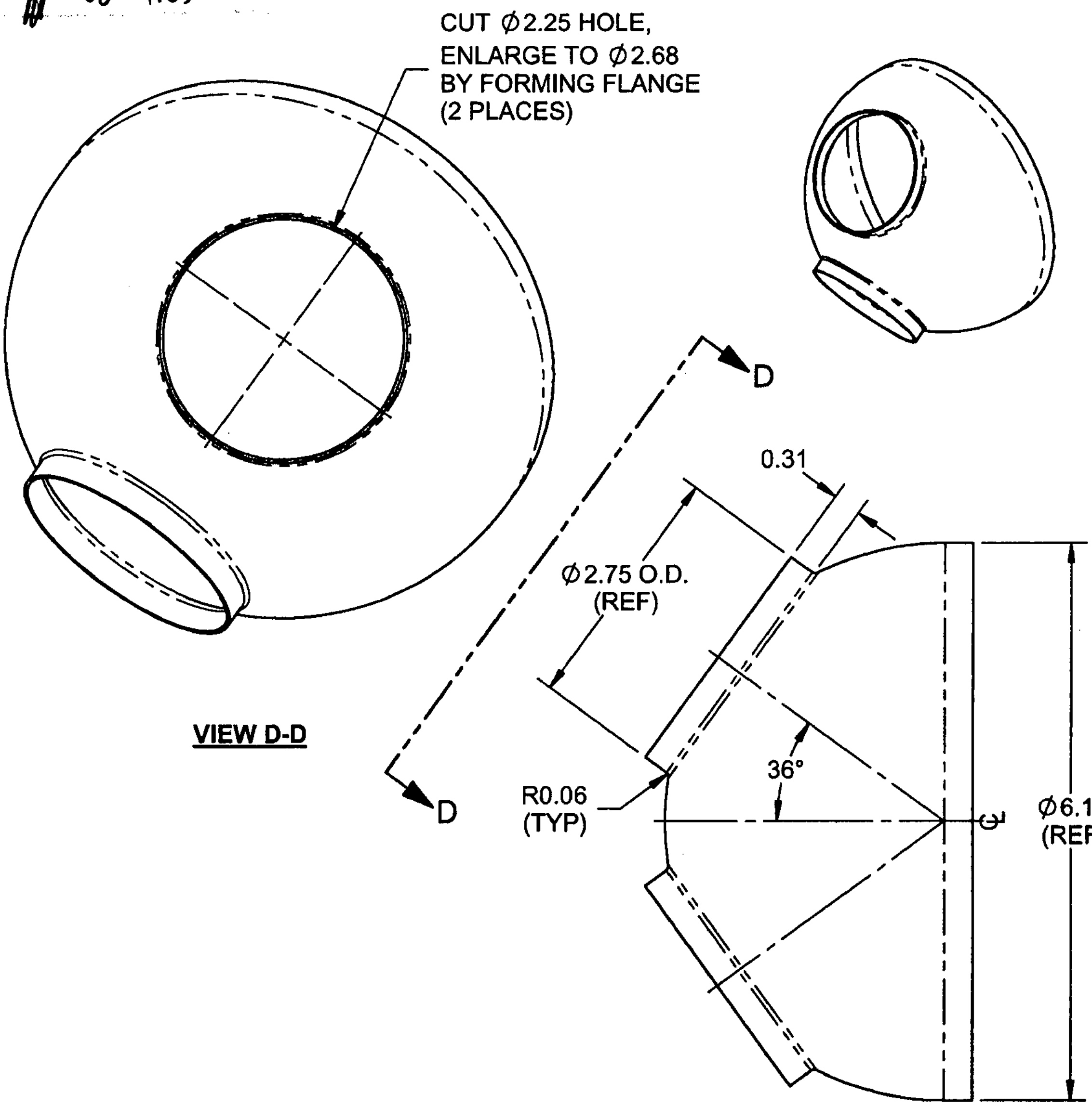
1) MATERIAL: AISI 304/316 SS SHEET, 0.036 THICK PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S20GA)
2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING OF MATERIAL (MINIMUM THICKNESS = 0.025").
3) FINISH: NONE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER
NO. 34440

DESIGN B	DRAWN BY B	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3476 — REV. A — SHEET 5 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER — SCALE 1:2

DART

06.04.03



D3476-3 DOME

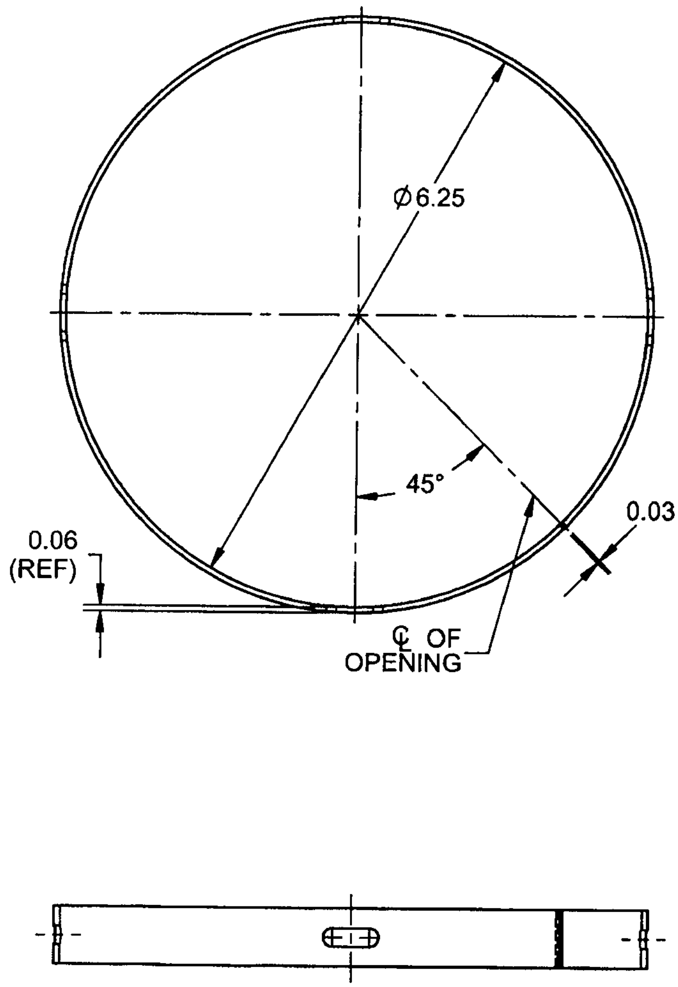
NOTES:

1) MATERIAL: MAKE FROM D3476-3S
2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT CENTERLINE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

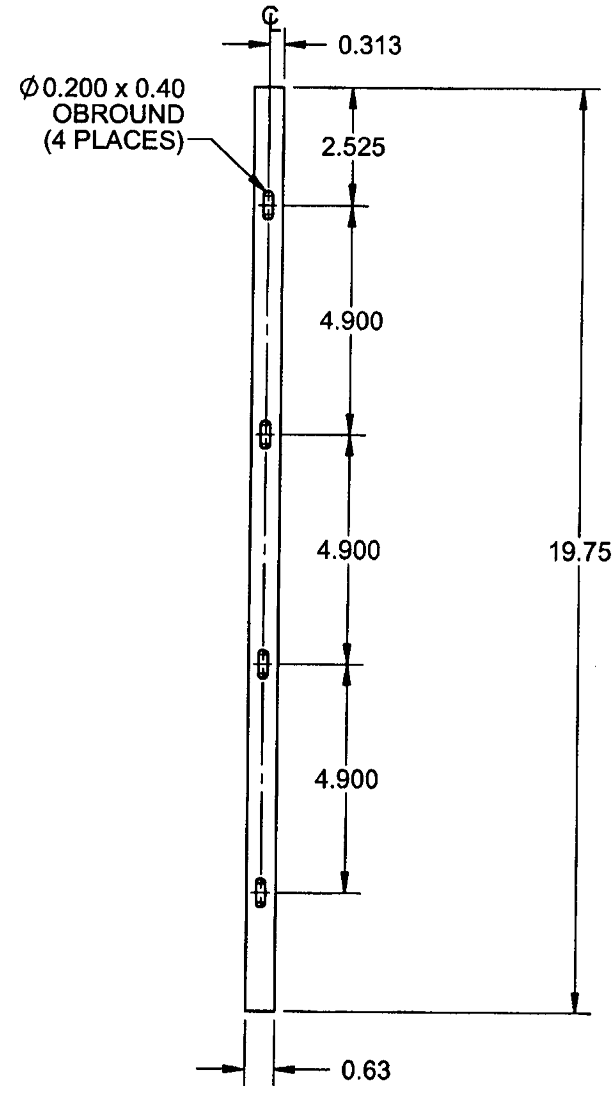
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3476	REV. A SHEET 6 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

DART

06.04.03



D3476-5 SPACER-RING



D3476-5F SPACER-RING FLAT PATTERN

NOTES:

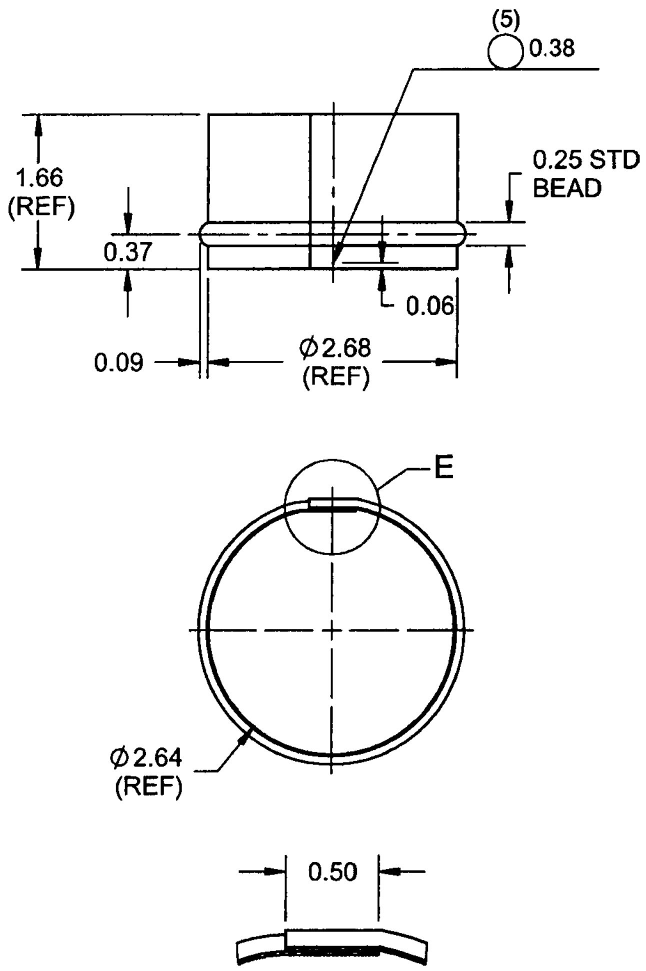
1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED)
   2B FINISH (REF. DART SPEC. M304S16GA)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER
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CHECKED	APPROVED	DRAWING NO. D3476 — REV. A — SHEET 7 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER — SCALE 1:2

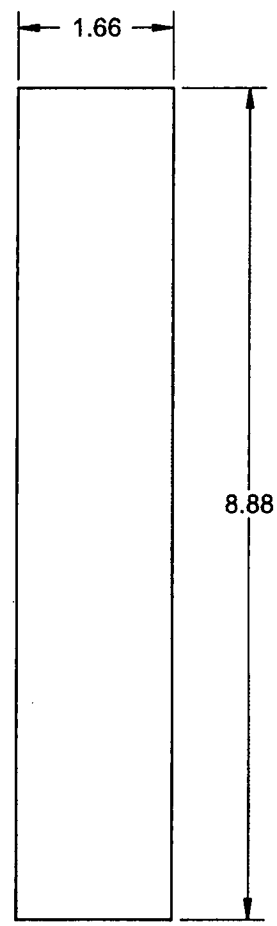
DART

06.04.03



DETAIL E
SCALE 1 : 1

D3476-7 TUBE



D3476-7 TUBE
FLAT PATTERN

NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
2) SPOT WELD PER DART QSI 004
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C '

TEST NO#: 5

EMPLOYEE: Melanie Fauteux

PART NUMBER: D3476-043

JOB NUMBER: B 34440

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION
- ☐ Group 1: Aluminum & magnesium
- ☐ Group 2: Iron; nickel; cobalt
- ☑ Group 3: Titanium

TEST RESULTS

	PASS	FAIL	
VISUAL:	[✓]	[ ]	
PENETRATION:	[✓]	[ ]	
PULL STRENGTH:	[✓]	[ ]	PSI Reading: ________

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/09/06
QUALIFIER: SB